

# Work Order ID 86555

**\*86555\***

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July-05-12 10:19:16 AM

Item ID: D350-588-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/05/12 Start Qty: 5.00 **\*5\***

Cust Item ID:

Required Date: 7/13/12 Req'd Qty: 5.00 **\*5\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	Packaging					5x			SP
Packaging	Memo	0.00							12-8-29
Packaging	Identify and pack for shipping as per PPP D350-588-011								
	Location: <u>122</u>								
	PPP Rev: <u>E</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

MLJ 12/08/30

U120829



# Picklist Print

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Work Order ID: 86555

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/05/12

Required Date: 7/13/12

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:M04.08.31Added D2690-17KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S/S AN526C1032R7 Screw		Purchased	No			120	Each	70.0000	2	10 SP			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST348		70							
				116304		10							
				119449		60				10x			
S/S AN526C832R8 Screw		Purchased	No			120	Each	127.0000	8	40 SP			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST346		115							
				120717		15				10x			
				122151		100				10x			
				ST347		12							
				116410		3				3x			
				116471		5				5x			
				118926		4							
S/S AN526C832R9 Screw		Purchased	No			120	Each	403.0000	8	40 SP			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST346		394							
				120181		21							
				121556		173							
				122151		200				70x			
				ST347		9							
				118983		9							
S/S AN960JD10 Washer	NAS1149D0363J	Purchased	No			120	Each	0.0000	4	20 M122378 SP			
S/S AN960JD8 Washer	NAS1149DN832J	Purchased	No			120	Each	0.0000	24	120 M120422 SP 12-8-10			



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Work Order ID: 86555

Parent Item: D350-588-011

Start Date: 7/05/12

Required Date: 7/13/12

Parent Item Name: Aft Door Fwd Hinge Modification

Start Qty: 5.00

Required Qty: 5.00

D2143 Manufactured No

120 Each 29.0000

1 5

Hinge Bracket

Location

Loc Qty

Loc Code

ST -28  
76100 10  
ST004 19  
82335 19  
ST198 38

5x

D2144 Manufactured No

120 Each 7.0000

1 5

Hinge Bracket

Location

Loc Qty

Loc Code

ST005 7  
78993 7

5x

D2150 Manufactured No

120 Each 36.0000

2 10

Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST005 36  
82136 16  
85513 20

10x

D2151 Manufactured No

120 Each 40.0000

2 10

Packer Doubler, Hinge

Location

Loc Qty

Loc Code

ST005 40  
82137 20  
85514 20

10x

D2153 Manufactured No

120 Each 55.0000

1 5

Door Prop

Location

Loc Qty

Loc Code

ST272 55  
78369 19  
85865 36

5

5

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Work Order ID: 86555

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/05/12

Required Date: 7/13/12

Start Qty: 5.00

Required Qty: 5.00

D2154

Stud Bracket

Manufactured No

120 Each 60.0000

0

## Location

## Loc Qty

## Loc Code

ST005

60

64312

1

77024

3

82333

56

1X

3X

1X

D2237

Striker Plate

Manufactured No

120 Each 62.0000

2

10

## Location

## Loc Qty

## Loc Code

ST006

42

64426

2

66139

1

82062

3

83376

36

10X

ST009

20

85476

20

D2461

Neoprene "D" Seal

Manufactured No

120 f 685.0967

7.25

38.157895

cut 1 X 87.00

## Location

## Loc Qty

## Loc Code

ST402

185.096684

39782

6.5

55054

4

63880

14.8237

73644

159.772984

ST402A

500

85225

500

14.5 4X

24.75 3X

D2463

Seal

Manufactured No

120 f 518.0674

7.25

38.157895

cut 1 X 87.00

## Location

## Loc Qty

## Loc Code

ST404

518.06737

72232

15.38

79478

2.68737

83542

500

38.16

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Work Order ID: 86555

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/05/12

Required Date: 7/13/12

Start Qty: 5.00

Required Qty: 5.00

**D2583**  
Latch Bracket

Manufactured No

120 Each 61.0000

2

10

Location

Loc Qty

Loc Code

ST011

61

83445

15

85427

46

Manufactured No

120 Each 72.0000

2

10

Location

Loc Qty

Loc Code

ST011

72

73297

2

82029

20

83369

6

85425

44

Manufactured No

120 Each 100.0000

2

10

Location

Loc Qty

Loc Code

ST203A

100

78833

1

83893

99

Manufactured No

120 Each 21.0000

U

5

Location

Loc Qty

Loc Code

ST011

21

74522

1

78893

20

Manufactured No

120 Each 0.0000

1

5

**D2589**  
Keys, Key Chain, 350 Hinge

**D2586**  
Door Latch

**D2587**  
Door Slug, 350 Hinge

B58194  
SP B-8-13.

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Work Order ID: 86555

Parent Item: D350-588-011


Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/05/12

Required Date: 7/13/12

Start Qty: 5.00

Required Qty: 5.00

 **D2690-17**  
Gable

Manufactured No

120 Each 27.0000

 5 

Location

Loc Qty

Loc Code

ST016

27

64786

1

66510

1


84069

19

85866



6

1x  
4x

 **D2857-1**  
Hinge Bracket

Manufactured No

120 Each 28.0000

 5 

Location

Loc Qty

Loc Code

ST019

28


75253

4

82261

24

3x  
2x

 **D2857-2**  
Hinge Bracket

Manufactured No

120 Each 16.0000

 5 

Location

Loc Qty

Loc Code


ST019

16

78904

16

5x  
5

 **D2858-1**  
Hinge Bracket

Manufactured No

120 Each 37.0000

 5 

Location

Loc Qty

Loc Code

ST019

37

63695

1

77019

12

82337



24

5x

 **D2858-2**  
Hinge Bracket

Manufactured No

120 Each 32.0000

 5 12-8-9 

Location

Loc Qty

Loc Code

ST019

32

64787

1

77020

8

82336

23

5x

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Work Order ID: 86555

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/05/12

Required Date: 7/13/12

Start Qty: 5.00

Required Qty: 5.00

FC-778150-550-ROL

Purchased No

120 sf 2,802.4910 1

7781 9oz Glass 50"x125yd

1-cut 1 square ft of glass cloth

## Location

## Loc Qty

## Loc Code

CA

2802.491

104845

3

108932

18

111166

392

113905

564

117602

664.651

119099

1160.84

MS20426AD3-4

Purchased No

120 Each 2,594.0000

RIVET

## Location

## Loc Qty

## Loc Code

ST316

2594

104374

236

110398

2358

MS20470AD4-5

Purchased No

120 Each 1,192.0000

Rivet, Universal Head

## Location

## Loc Qty

## Loc Code

ST319

1192

118405

405

120142

787

MS21042L08

Purchased No

120 Each 854.0000

Nut

## Location

## Loc Qty

## Loc Code

ST300

54

121524

54

ST317

800

122141

800

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Work Order ID: 86555

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/05/12

Required Date: 7/13/12

Start Qty: 5.00

Required Qty: 5.00

MS2104213

Purchased

No

120

Each

3,330.0000

20

Nut

## Location

## Loc Qty

## Loc Code

ST300

1330

117885

32

119017

771

119075

138

121444

389

ST317

2000

122141

2000

MS27039-08-11

Purchased

No

120

Each

59.0000

10

Screw

## Location

## Loc Qty

## Loc Code

ST290

7

117441

7

ST292

52

116289

2

120833

50

MS27039-1-15

Purchased

No

120

Each

31.0000

Screw

## Location

## Loc Qty

## Loc Code

ST291

31

118574

2

119736

1

121243

28

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## 52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

\* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

## 52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	1/2" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)7

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# Work Order ID 86555

**\*86555\***

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Item ID: D350-588-011

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Door Fwd Hinge Modification

Start Date: 7/05/12 Start Qty: 5.00

**\*5\***

Cust Item ID:

Required Date: 7/13/12 Req'd Qty: 5.00

**\*5\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

*SP*

0.00

*DAS 16 9-83*

*1768/29*

0.00

*MCS 12/08/10*

**\*100\***

DOCUMENT CONTROL

DC

Memo

Document Control

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

110

Pick Kit

0.00

**\*110\***

0.00

Packaging

Memo

Packaging

*5x*

*SP 12-8-9*

120

QC4- 100% Inspect kits for completeness

0.00

**\*120\***

0.00

QC

Memo

Quality Control

*DAS 16 9-83*

*1768/29*

*6*

87